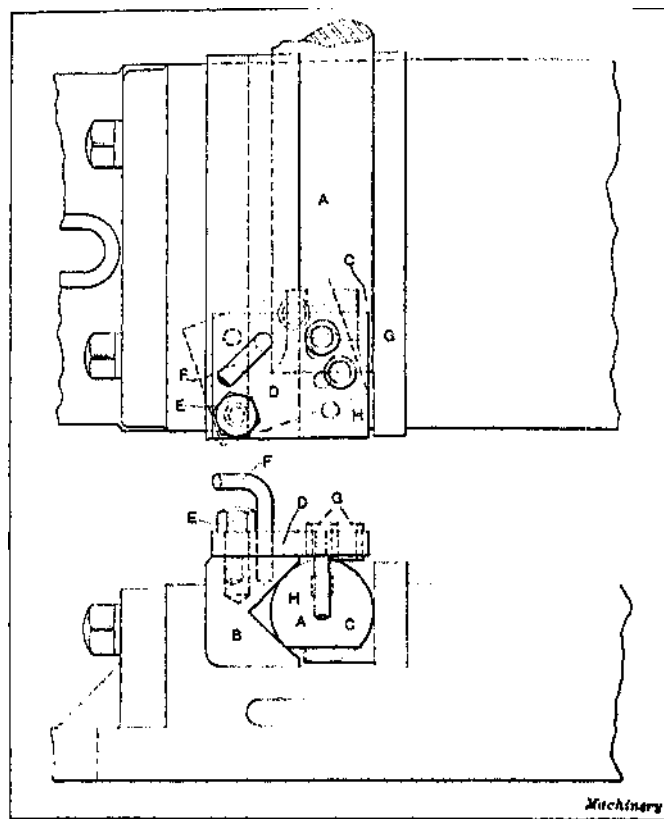


**A Vise Drilling Jig.** —Fig. 16 shows a jig for drilling and milling an elongated hole in a piece of work where the limit of accuracy required is not less than  $\pm 0.003$  inch. A flanged milling machine vise was fitted with a special jaw having a V-groove cut lengthwise, as shown at *B*. Pin *C* was put into



**Fig. 16. Vise Drill Jig with Swivellag Leaf for Forming an Oblong Hole**

a soft jaw on the movable slide of the vise and located so that the milled surface of shaft *A* would rest on the upper surface of the pin and hold the shaft level for drilling. Bushing plate *D* was next put on and held in place by a cap-screw *F*. Bushing plate *D* was then laid out and drilled and

reamed in position for the locating pin  $F$  and the drill and counterbore bushings  $G$ . The stop-pin  $H$  was located in the hushing plate  $D$  to insure